

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005001**Date Inspected:** 12-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	OBG Longitudinal Stiffeners OBG Bay 7: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001629, items #6 thru 15. The subassemblies are identified as OBG longitudinal diaphragms; LD017-007-002 & 003, LD018-007-002 & 003, LD003-021-001 & 002, LD002-013-005 & 006, LD001-013-001 & 005, LD012-003-004 & 012, LD004-021-004 & 012, LD001-003-002 & 012, LD004-004-004 & 003 and LD006-004-006 & 007 cover pass weld. The cover pass welds appeared to be QC-MT inspected and accepted by ZPMC. Caltrans QA-MT coverage was approximately 10%. The cover pass welds were found to be in compliance with the project specification. See Caltrans Magnetic Test Report (TL-6028) dated, 12-12-2008 for additional information.	NA	NA	QA-MT
2	OBG Floor Beams OBG Bay 7: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001628, items #4 & 5. The subassemblies are identified as OBG floor beams; weld FB003-099-008 & 020 and FB003-103-008 & 020. Caltrans QA inspector observed that the welds have been UT inspected and accepted by ZPMC QC. Caltrans QA-UT coverage was approximately 10%. The welds appeared to be in	NA	NA	QA-UT

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conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, 12-12-2008 for additional information.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann 150-0219-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
